Date:

Thursday, 9/21/2006 3:24:10 PM

User:

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number **Estimate Number** : 28693

: 10725

P.O. Number

:NIA

: 9/21/2006 This Issue

Prsht Rev. First Issue

: NA

: 28402

S.O. No. : NIA

Type

: MACHINED PARTS

Drawing Number

Project Number **Drawing Revision**

Drawing Name

Part Number

Material

NG

Due Date

: N/A

: D2652

: D2652 REV A

: BUSHING

: 10/3/2006

Qty:

200 Um:

Each

Written By

Previous Run

Checked & Approved By Comment

: Est Rev:B

Now machined in house.

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

M303R0500 1.0

303 Round Bar 0.500"

11.5500 f(s)

Comment: Qty.:

0.0578 f(s)/Unit Total:

Material:303 ss .500" Round Bar

(M303R0500)

Batch: MIOL448

06109124

2.0





Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA250 & Dwg D2652

2-Deburr

INSPECT PARTS AS THEY COME OFF MACHINE

06/09/24

200

3.0

QC2



Comment: INSPECT PARTS AS THEY COME OFF MACHINE



QC8

ゴ,G

200

4.0

SECOND CHECK

Comment: SECOND CHECK

E

700

5.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Dart Aerospace Ltd

W/O:			WC	RK ORDER CHANGE	3			I	
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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						-			
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes⁄	No DQ	A: <u>C</u>	<u> </u>	6/09/26
					QA: I	N/C Close	d:	Date:	
NCR:			WORK ORDE	ER NON-CONFORMAN	CE (NCI	₹)		,	
DATE	CTED	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
DATE	STEP	STEP Section A	Initial Chief Eng	Action Description Chief Eng	Sign of Date	🙎 Secti	Section C	Chief Eng	QC Inspector
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								,	

NOTE: Date & initial all entries

Date:

Thursday, 9/21/2006 3:24:10 PM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 28693

Part Number: D2652

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE







Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Joy/26

Dart Ae	rospace	Ltd						:	
W /O:		,	W	ORK ORDER CHANGE	S				
DATE	STEP	:				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		;						ŧ	
							,	:	
		:							
Part No	:	PAR #:	Fault Cate	egory:	NCR: Yes	No DQ	A :	_ Date: _	
		:			QA: N	I/C Closed	d:	_ Date: _	
NCR:		· .	WORK ORD	ER NON-CONFORMAN	ICE (NCF	₹)			
	T	Description of NC		Corrective Action Section	В	Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section		Chief Eng	QC Inspector
							:	÷	
		<u> </u>							

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	28693
Description: Bushing	Part Number:	D2652
Inspection Dwg: D2652 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X Fi	rst Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.600	+/-0.010	0.596				
0.060	+/-0.005	0.060				
Ø0.305	-0.002/+0.000	0.304				
Ø0.191	+0.005/-0.000	0.194				
Ø0.500	+/-0.010	0.499				
0.030 x 20°	+/-0.010	0-030 8200				
R0.010	+0.010/-0.000	0.015				
- 11 12						
						77

Measured by: 5 _ 6	Audited by:	Prototype Approval:	N/A
Date: 06/09124	Date: 06.04.14	Date:	SIA

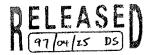
Rev	Date	Change	Revised by	Approved
Α	03.12.12	New Issue	KJ/RF	14

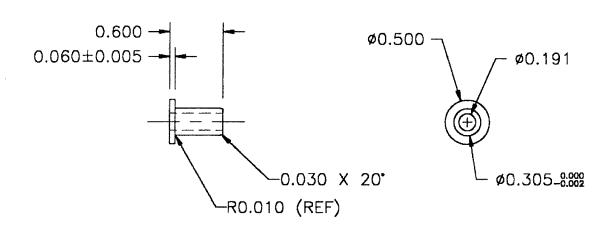
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DESIGN	DRAWN BY		PACE USA, INC.
CHECKED	APPROVED	DRAWING NO.	REV. A
BW	10/08	D2652	SHEET 1 OF 1
DATE		TITLE	SCALE
97:03:25		BUSHING	1:1





MATERIAL: AISI 303 SS

NOTE: BREAK ALL SHARP CORNERS 0.010 MAX

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED COPY UNCONTROLLED COPY

SUBJECT TO AMENDMENT

SHOP COPY

WITHOUT NOTICE